

test fit

Work Order ID 145505

145505

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Friday, May 06, 2016 7:15:37 AM

Item ID: D3969-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Spring (Basket Lid)
 Start Date: 5/6/2016 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 5/12/2016 Req'd Qty: 2.00 *2* Customer:

Reference:

Approvals: Process Plan: DAS 13 9-89 Date: MAY 06 2016 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3969	C								

100

0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 32279
 Order as per Dwg D3969
 Possible supplier: LS Technologies
 part#: SSA4/8-122-310-360N
 Material release note is required

0.00

see drawing attached
 as per Mike Lee.

2

MAY 06 2016

DAS
13
9-89

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

***Measure compression only at
 5mm on gas spring***

0.04

2x 8016-05-11

Work Order ID 145505

Friday, May 06, 2016 7:15:37 AM

145505

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Item Name: Spring (Basket Lid)
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo ***Measure compression only at 5mm on gas spring***	0.00 0.00				<u>2</u>			DAS 38 9-89 MAY 11 2016
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.02				<u>2</u>	<u>1</u>		JAN 10 2017
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.20							used for test fit DAS 21 9-89 JAN 17 2017 JAN 10 2017

Charged to
017-01

JAN 10 2017

Picklist Print

Friday, May 06, 2016 7:15:36 AM

Page 1
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Work Order ID: 145505

145505

Parent Item: D3969-3

D3969-3

Parent Item Name: Spring (Basket Lid)

Start Date: 5/6/2016

Required Date: 5/12/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
per revC DD 10.03.16 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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SSA4/8-122-310-360N

Purchased

No

110

Each

10.0000

1

2

SSA4/8-122-310-360N

**

2x SP/6-05-11

Gas Spring

Location

Loc Qty

Loc Code

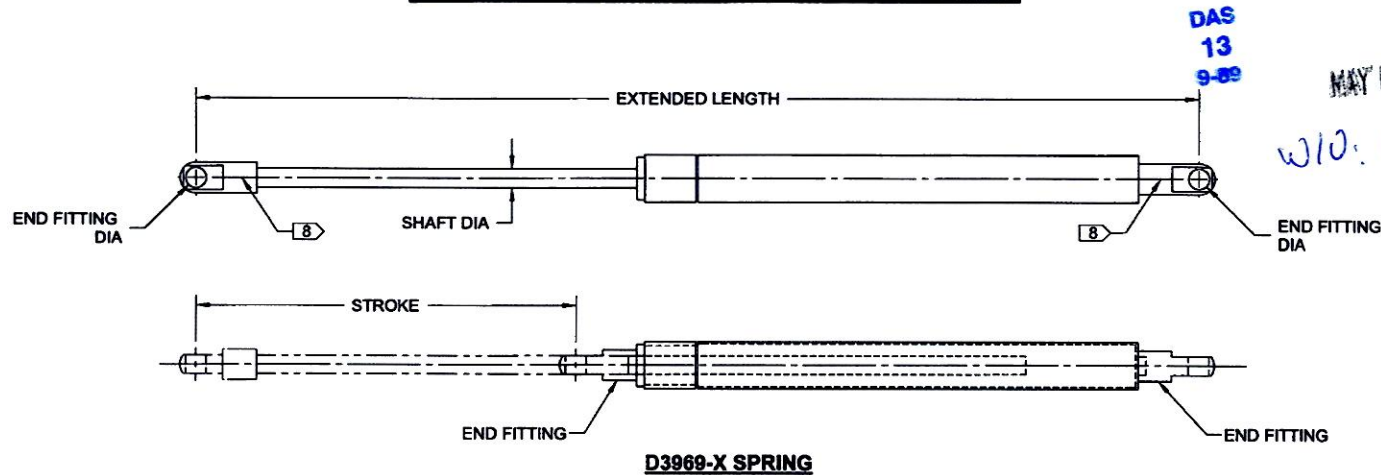
ST

10

143820

10

SPECIFICATION CONTROL DRAWING



DART PART NUMBER	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	SHAFT DIA (mm/in)	FORCE (N/lbs)	END FITTING TYPE	END FITTING DIA (in)	CASING MATERIAL	PREFERRED SUPPLIER	SUPPLIER PART NUMBER	WEIGHT APPROX
D3969-1	120/4.70	315/12.40	8/0.24	310/69.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-310N	0.27 lbs
D3969-3	120/4.70	315/12.40	8/0.31	360/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-310-360N	0.32 lbs
D3969-5	120/4.70	315/12.40	8/0.24	133/29.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-133N	0.27 lbs

ORDER D3969-3 WITH A MODIFIED EXTENDED LENGTH OF 13.5" FOR TESTING PURPOSES. MAY BECOME D3969-7 IF TESTING PASSES.

THANKS

MFA 2016.05.06

** as per qc inspection (13.625)

NOTES:

- 1) MATERIAL: SEE CHART
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3969-X" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE CHART
- 8) CRIMP END FITTING AT APPROXIMATE LOCATION SHOWN, PER MANUFACTURERS REQUIREMENTS

C	REDRAWN IN SW. ADDED -3 & -5; ADDED SHAFT DIA COLUMN TO CHART. FORCE FOR -1 CORRECTED (WAS 80.0 lbs).	JPH	10.03.04
B	DRAWING RENAMED WAS: GAS SPRING (BASKET LID). NOTE 8 ADDED.	AJS	09.11.10
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	N/A	D3969	SHEET 1 OF 1
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BASKET LID SPRING	NTS
DATE	10.03.04	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2010-03-12

DAS
13
9-89

MAY 0 6 2016
W10.145505

DAS
38
9-89



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32279

Purchase Order Date 5/6/2016
PO Print Date 5/6/2016

Page Number 1 of 1

Order From :
LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

VC-LST0001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
MAY 06 2016

Contact Name
Vendor Phone 306 683 5000

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	SSA4/8-122-310-360N	Gas Spring	5/11/2016 Yes 5/11/2016		2.00 Each	\$66.90	\$133.80
	AS PER D3969-3 WITH A MODIFIED EXTENDED LENGHT OF 13.5" TESTING PURPOSES, MAY BECOME A D3969-7						
						Line Total:	\$133.80
2	71401-45	PROCUREMENT QUALITY CLAUSES	5/11/2016 No 5/11/2016		1.00	\$0.00	\$0.00
	Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A016 personnel qualification A025 certification of conformance A040 nification of quality escape A043 retention of quality documents						
						Line Total:	\$0.00
						PO Total:	\$133.80

PO Instructions: Fedex Acc#151793240

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 5/6/2016

LS Technologies Inc
314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph: 306-683-5000 Fax: 306-683-6403

Packing Slip

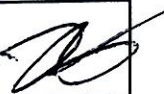
P.O. No.	Date	Invoice #
32279	5/10/2016	14809

Bill to:
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship to:
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
5/10/2016	Fed-Ex	

Qty	Description
2	D3969-** Stainless Gas Spring (SSA4/8-130-343-360N) Shipping Via FED EX Tracking # 776308911303 <i>5/16/05-11</i>

Order checked by 



LS Technologies Inc

314 Jessop Ave

Saskatoon, SK, S7N 1Y6

Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Conformance

May 10, 2016, 2016

This is to certify that the parts listed below meets specifications as required by your order.

2 Units : SSA4/8-130-343-360N Stainless Gas Spring

Country of Manufacture : Canada

Date of Manufacture : May 2016

This product is ROHS compliant.

Purchase Order # 32279

Inv# 14809

L S Technologies Inc Canada

**Nolan Fehr
President**